

Date: Wednesday, 31/01/2007 3:02:38 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-742-013
Job Number	: 30472	Part Number	: D412742013
Estimate Number	: 10804	Drawing Number	: DSI 9369 9364 R1 07.01.31
P.O. Number	:	Project Number	:
This Issue	: 31/01/2007 S.O. No. :	Drawing Revision	:
Prsht Rev.	: NC	Material	:
First Issue	: 26/01/2007 Type : LANDING GEAR	Due Date	: 02/02/2007 Qty: 1 Um: Each
Previous Run	: 00015		
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
REMOVE FROM STK:
D412-742-013 B 29926

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364. ENSURE WEARPLATE IS INSTALLED.
-TEST FIT D3591-1 BUSHING AND SADDLES.
-REMOVE D3591-1 BUSHINGS
D3591-1 B 30571

B) - REMOVE D3391/021 FWD TUBE AND DEBURR ALL HOLES
- TOUCH UP ALODINE

C) - RE-INSERT D3391-021 FWD TUBE. INSTALL WEARPLATES.
COAT BUSHINGS WITH LPS3 B 17168
INSTALL BUSHINGS - TEST FIT SADDLE HARDWARE

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 31/01/2007 3:02:38 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 30472

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REINSPECT KIT FOR 100% COMPLETENESS

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP USING NEW B/N.
NEW PAPERWORK & LABELS REQ'D
CHG002
-ENSURE DSI PAPERWORK IS INCLUDED-

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 10:09:57 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-742-013
Job Number : 30472	
Estimate Number : 10804	
P.O. Number :	Part Number : D412742013
This Issue : 26/01/2007	Drawing Number : DSI 9369 <i>9364 PH 07.01.31</i>
Prsht Rev. : NC	Project Number :
First Issue : 1/1	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 02/02/2007
Checked & Approved By :	Qty: 1 Um: Each
Comment :	

Additional Product

Job Number:



CHG 002

Seq. #:	Machine Or Operation:	Description :
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1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
REMOVE FROM STK:
D412-742-013 B

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
A) -DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI *9364* ~~9369~~. ENSURE WEARPLATE IS INSTALLED.
-TEST FIT D3591-1 BUSHING AND SADDLES.
-REMOVE D3591-1 BUSHINGS
D3591-1 B
B) - REMOVE D3391-021 FWD TUBE AND DEBURR ALL HOLES
- TOUCH UP ALODINE

C) - RE-INSERT D3391-021 FWD TUBE. INSTALL WEARPLATES. *COAT BUSHINGS WITH LPS-3 PH 07.01.31*
INSTALL BUSHINGS - TEST FIT SADDLE HARDWARE

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
REINSPECT KIT FOR 100% COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 10:09:58 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 30472

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP USING NEW B/N.

NEW PAPERWORK & LABELS REQ'D

-ENSURE DSI PAPERWORK IS INCLUDED-

CHG 002 PH 07.01.31

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9364	REV. A SHEET 1 OF 1
DATE 07.01.16		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

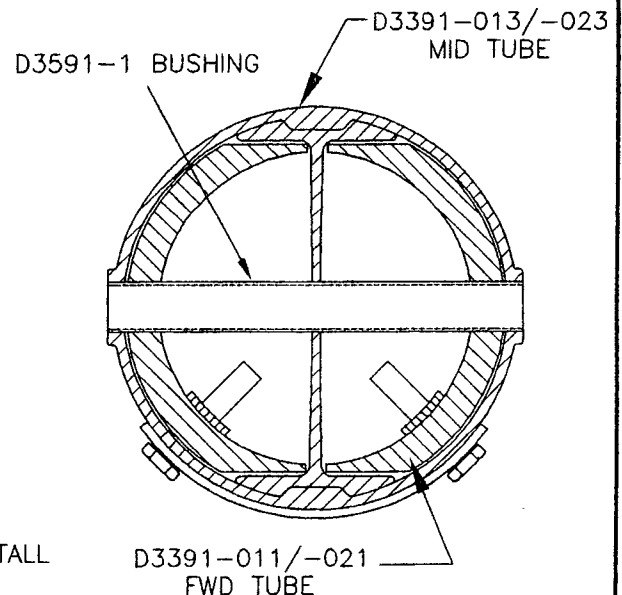
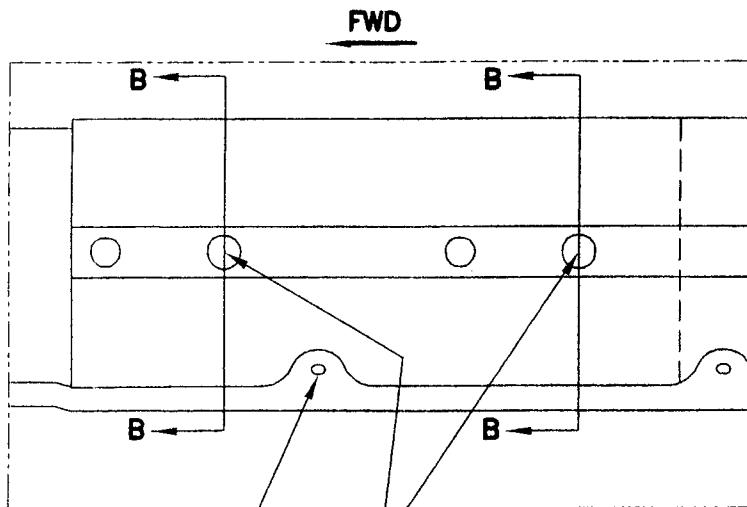
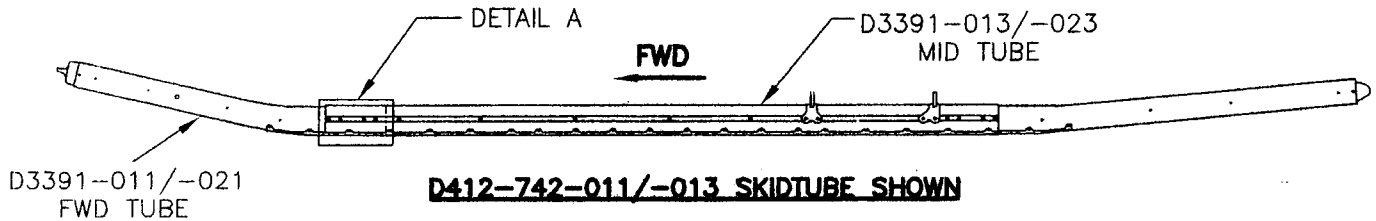
REFERENCE ONLY

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES (≥ 0.500) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\phi 0.500$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION

SECTION B-B

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